

Work Order ID 50758



Page 1

July 21, 2009 2:30:10 PM

Item ID: D2580-1

Accept



Setup Start



Revision ID: D

Stop

Item Name: 205 Skidtube bent detail

Start Date: 07/29/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 08/06/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 09-07-21 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
----------	--------------

D2580	Rev D
-------	-------

100



HandFinish

Memo

0.00

0.00

6 Ø - Am 9-7-29

Hand Finishing

1- Inspect mat'l D2500-1-190 for damage.

Seq 101

09/07/09 Qc3 inspection

0.00

2- Chemical Conversion Coat as per QSI 005 4.1

110



Skidtubes

Memo

0.00

Skidtubes

1- Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

0.00

2- Open holes to 0.500" as per Dwg D2580 without cutting fluid

0.00

3- Deburr and blow out all chips from inside of tube

0.00

4- Bond web in place per QSI 015.

0.00

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *10/20* *000*

Sikaflex expire date: *10/01/20*

11/557

Am 9-7-29

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

120



QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

Remove (add at Seq 101)
109/07/29

130



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

DP 9-7-30 (6)

140

Identify as per dwg & Stock Location: L.6

0.00

Packaging

Packaging

Memo

0.00

(6) 10 9-7-30

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July 21, 2009 2:30:10 PM

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Stop



Start Date: 07/29/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 08/06/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

0967/31

Draw
Rev.

H

Plan
Code

09-7-31

Accept
Qty

B1

Reject
Qty

0

Reject
Number

09-7-31

Insp.
Stamp

Memo

0.00

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Picklist Print

July 21, 2009 2:30:10 PM

Page 1

Work Order ID: 50758



Parent Item: D2580-1RevD



Parent Item Name: 205 Skidtube bent detail

Start Date: 07/29/2009

Required Date: 08/06/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190RevU/LG - Chassis Ext'n - I Beam Tube 4"		Manufactured	No			100	Each	0.0000	6.0000	B-46468	(6)	AwMg-7-29
D2596RevD		Manufactured	No			110	Each	4.0000	6.0000			
Web, 205 Skidtube												

Warehouse
Location

Main Warehouse

LG
50361
4

B-50764

Loc Qty

Loc Code

6
Awm S-7-30

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART

DESIGN <i>#</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 30/5/09-07-01-01*
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 2) ALL DIMENSIONS ARE IN INCHES
 - 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
 - 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
 - 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241-291.
 - 6) WELDING TO BE DONE PER DART QSI 004.
 - 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
 - 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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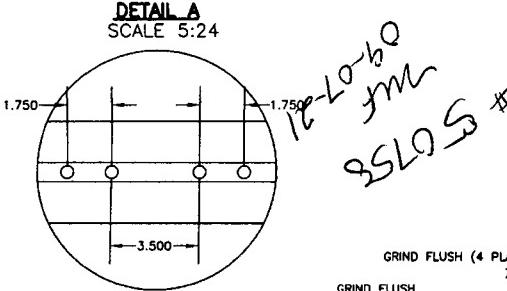
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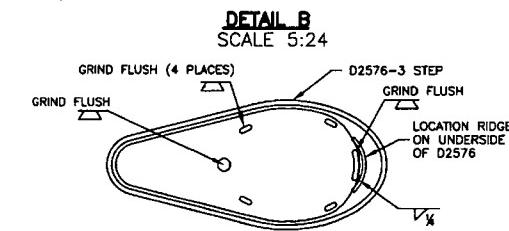
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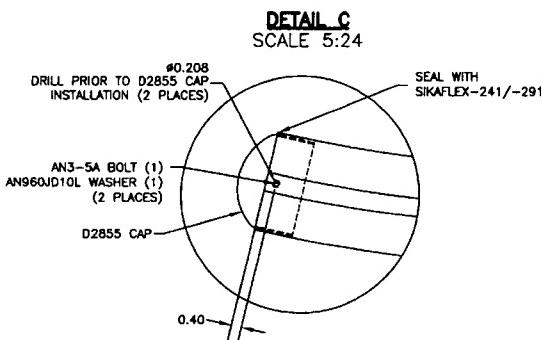


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07-06-28-1

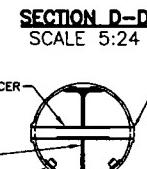
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DETAIL B
SCALE 5:24



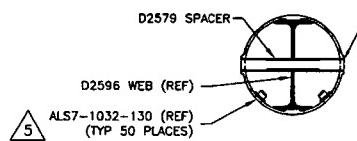
DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24

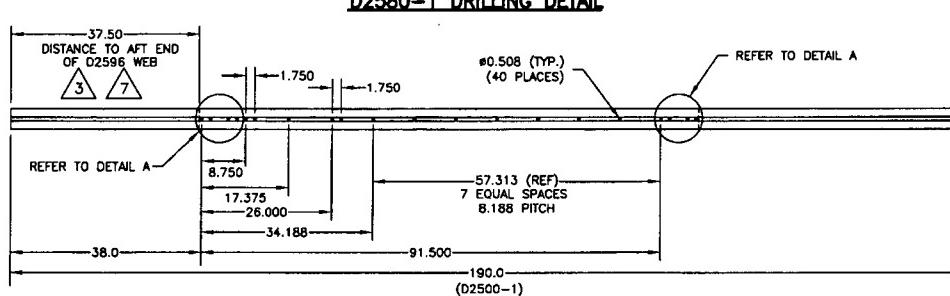
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP



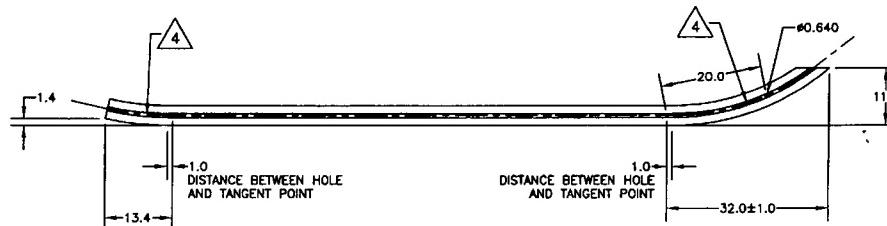
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

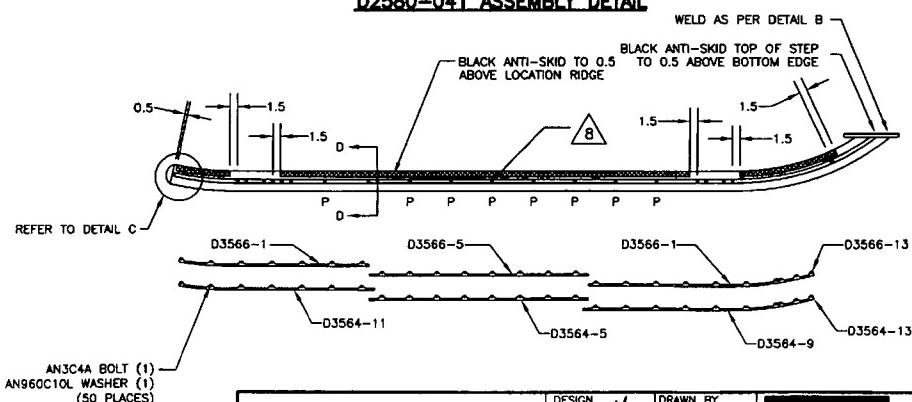


D2580-1 DRILLING DETAIL

D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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	DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24	

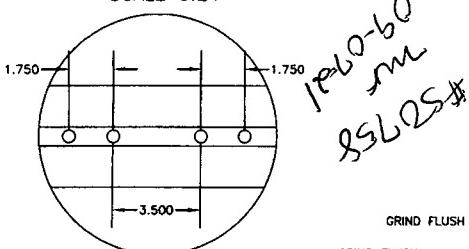
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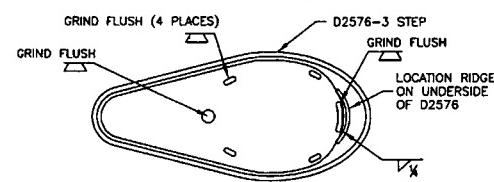
• NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

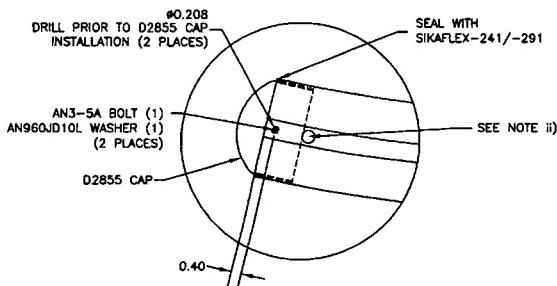


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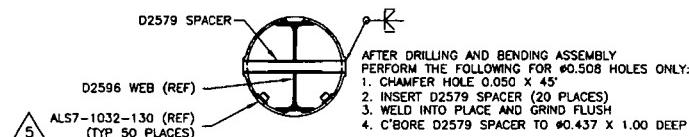
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

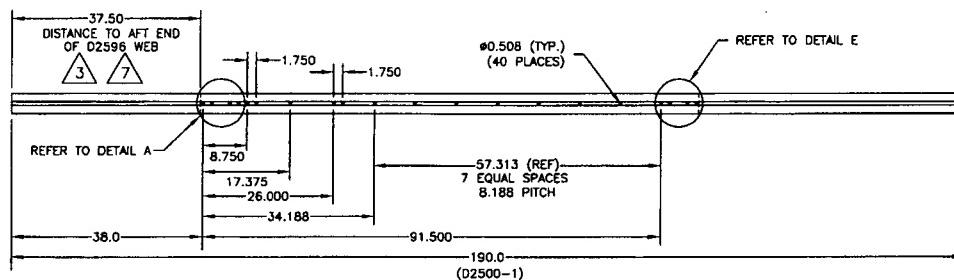


C

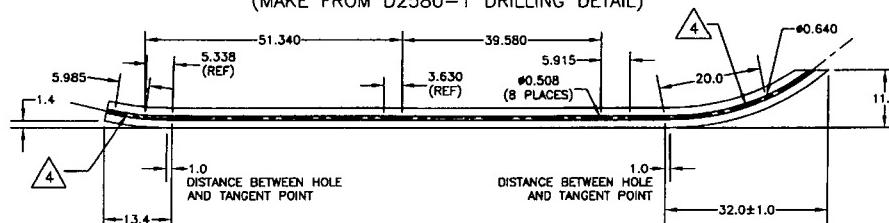
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

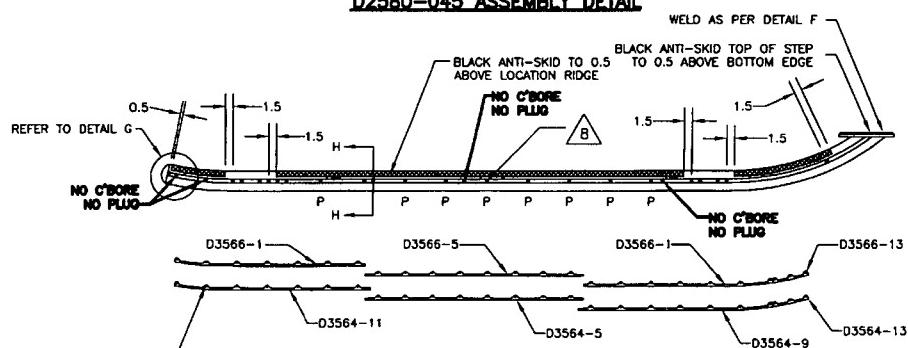
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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RH	RH	DART	REV. D
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE	

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